SPLIT

Dart Aerospace Ltd.

Date: Tuesday, 3/11/2008 7:57:35 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEARPAD
Job Number	: 37749 -2		
Estimate Number	: 12712		
P.O. Number	:	Part Number	: D35371
This Issue	: 3/11/2008 S.O. No. :	Drawing Number	: D3537 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 37292	Material	:
Written By	:	Due Date	: 3/31/2008 Qty: 100 Um: Each
Checked & Approved By	: 08 03 11		
Comment	: Est Rev:A New Issue 07-02-14 JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	M304S16GA	304/316 .063 Sheet

Comment: Qty.: 0.1113 sf(s)/Unit Total : 11.1300 sf(s)
M304S16GA .063" 304 SS SHEET
Batch: 107513 HB 8-3-26

2.0	WATER JET	FLOW WATER JET

Comment: FLOW WATER JET
1-Cut as per Dwg D3537
Dwg Rev: C HB 8-3-26
Prog Rev: C
2-Deburr if necessary HB 8-3-26

(120)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE

HB 8-3-26

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK

Comment: SECOND CHECK

08/08/27 (+120)

5.0	BRAKE NC	NC BRAKE

Comment: NC BRAKE
1-Form as per Dwg D3537 on CNC brake using Jigs DT 8261 and DT 8326.
2-Identify as D3537-1

SB 08/03/28 (120)

Form: process

Date: Tuesday, 5/11/2008 1:57:00 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 37749

Part Number: D35371

~~30~~ 30 min
13/05/2008
S.241 13.29
#1 319.5 F
#2 D3537-7 F
#3 ----- F
#4 37749 F

Job Number:

Seq. #	Machine Or Operation:	Description :
6.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

Qty	Description	Batch
A/R	2059B Hardcoat	107051 ~~-> 107087~~

1-Weld as per Dwg D3537 using Jig DT 8210
2-Remove any weld that penetrated through Wearpadif necessary 08-05-09. SP

28

7.0	QC10	VISUAL WELDING INSPECTION

08/05/09

Comment: VISUAL WELDING INSPECTION

counts
S 08/05/09 x28

8.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP

counts
S 08/05/09 x28

9.0	POWDER COATING	POWDER COATING

~~AA106~~ M/05642.

Comment: POWDER COATING
Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

FK 08/05/13 28

10.0	QC3	INSPECT POWDER COAT/CHEMICAL CONVERSION

28X

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M. L 08/05/13

11.0	PACKAGING 1	PACKAGING RESOURCE #1

28X

Comment: PACKAGING RESOURCE #1
Identify and Stock
Location: F-P 20 M. L 08/05/13

12.0	QC21	FINAL INSPECTION/W/O RELEASE

Comment: FINAL INSPECTION/W/O RELEASE

08/05/15

Job Completion

U 08.05.14

Form: process

DART AEROSPACE LTD	Work Order:	37749
Description: Wearpad	Part Number:	D3537-1
Inspection Dwg: D3537 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

[X] First Article [ ] Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
4.250	+/-0.010	4249	*			
3.500	+/-0.010	3.500	*			
1.965	+/-0.010	1.969	*			
2.795	+/-0.010	2.793	*			
3.625	+/-0.010	3.624	*			
0.220 x 0.380	+/-0.010	.224 x 382	*			

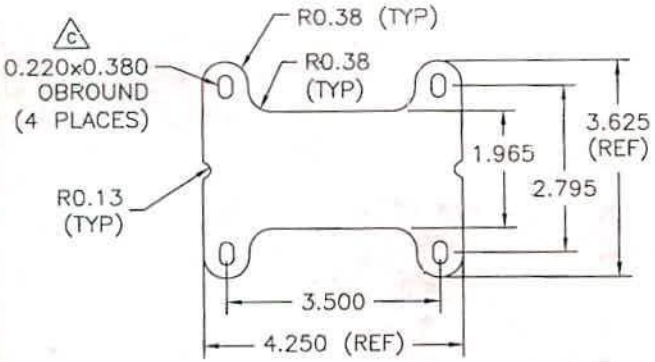
Measured by:	AB
Date:	8-3-26

Audited by:	
Date:	08/03/27

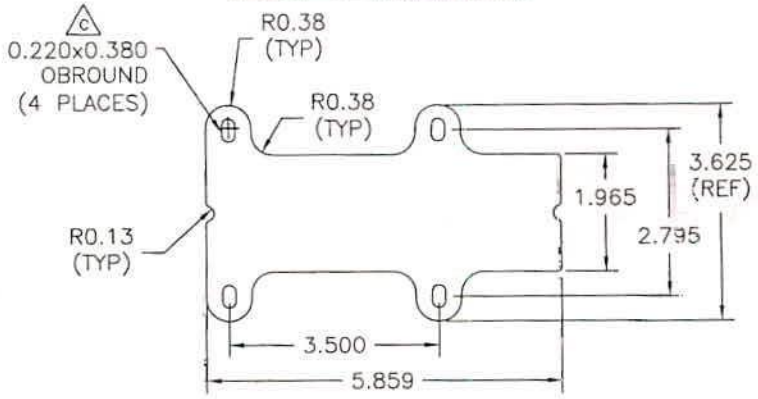
Prototype Approval:	N/A
Date:	N/A

Rev	Date	Change	Revised by	Approved
A	07.03.21	New Issue	KJ/JLM	
B	07.04.27	Dimensions revised per Dwg Rev. B	KJ/JLM	
C	07.05.28	Dimensions revised per Dwg Rev. C	KJ/JLM	

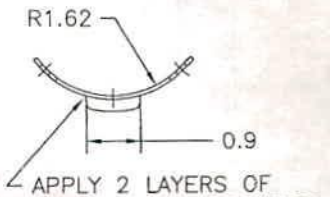
D3537-1F FLAT PATTERN



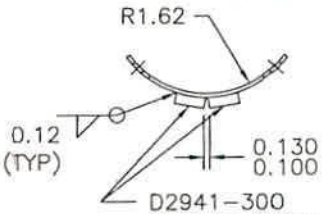
D3537-3F FLAT PATTERN



SECTION A-A

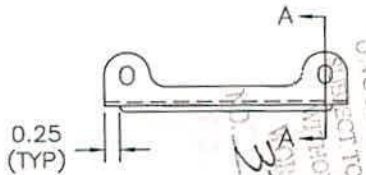


SECTION B-B

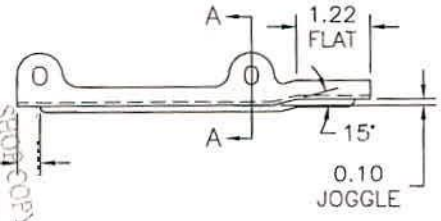


RELEASED
07.05.03 PH
per ECN 962

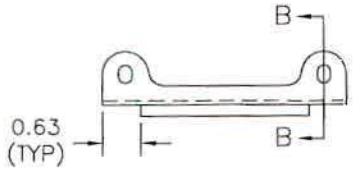
D3537-1 LONGITUDINAL BEND
(MADE FROM D3537-1F)



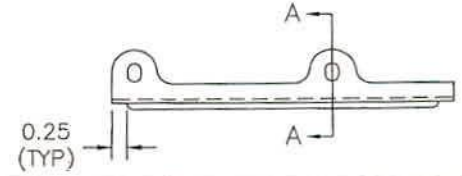
D3537-3 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-5 LONGITUDINAL BEND
(MADE FROM D3537-1F)



D3537-7 LONGITUDINAL BEND
(MADE FROM D3537-3F)



D3537-1/-3/-5/-7 WEARPAD NOTES

1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)
   (REF DART SPEC. M304S16GA)
2) BREAK ALL SHARP CORNERS 0.063 MAX
3) WELD PER QSI 004
4) FINISH: POWDER COAT GREY SANDTEX (4.3.5.6) PER QSI 005 4.3
5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
6) ALL DIMENSIONS ARE IN INCHES

C	07.04.13	WIDEN TAB TO 0.380, WELD PATTERN
B	07.03.20	ADD AMS 5513 AND AMS 5524
A	06.11.06	NEW ISSUE

DESIGN: CB	DRAWN BY: PH	DART AEROSPACE USA, INC. PORT HADLOCK, WA.	
CHECKED:	APPROVED:	DRAWING NO. D3537	REV. C
DATE: 07.04.13		TITLE: WEARPAD	SCALE: 1:2
			SHEET 1 OF 1